

Application No.: 10/658,243

**Amendments to the Claims**

Please amend claim 1 as follows by replacing "second" recited in line 8 of claim 1 with "opposite", and also replacing "second" recited in line 10 with "opposite end":

**Claim 1 (Currently Amended):** A method for manufacturing a crank arm and spider assembly comprising the following steps:

- (1) providing a blank;
- (2) shaping the blank to form a crank billet comprising an elongate body having a first end on which a spider is integrally formed and an opposite end having an expanded outside diameter;
- (3) forming a channel substantially co-extensive with the elongate body with an opening an the ~~second~~opposite end of the body;
- (4) reducing the expanded second end and thereby reducing inside diameter of the channel in proximity of the ~~second~~opposite end for forming an entry of the channel;
- (5) filing a liquid into the channel through the entry and then sealing the entry;
- (6) placing the crank billet with the liquid filled in the channel into a mold and performing a mold forging operation to obtain a semi-product; and
- (7) forming a hole in the body to release the filling liquid out of the channel of the crank.